

Date: Monday, 02/03/2009 11:24:04 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOUBLER
Job Number : 46177	
Estimate Number : 10892	
P.O. Number :	Part Number : D32861
This Issue : 02/03/2009 S.O. No. :	Drawing Number : D3286 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 44307	Material :
Written By :	Due Date : 20/03/2009 Qty: 4 Um: Each
Checked & Approved By : <u>JUD 09.03.02</u>	
Comment : Est A 04.07.14 New issue KJ/JLM Est Rev:B Now on Waterjet 06-06-16 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S11GA	304/316 0.125 Sheet
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Comment: Qty.: 0.0786 sf(s)/Unit Total : 0.3146 sf(s)

304/316 .125 Sheet

Patch: 109358

ml 09 03 05

(4)

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D3286

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

ml 09 03 05

(4)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

ml 09 03 06

(4)

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK

S 09/03/06

(4)

5.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE

Form as per Dwg D3286

S 09/03/06 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 02/03/2009 11:24:04 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 46177

Part Number: D32861

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

802/03/25 (X4)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5783

09/03/25 (9)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/25

Job Completion



mf 09-03-25

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

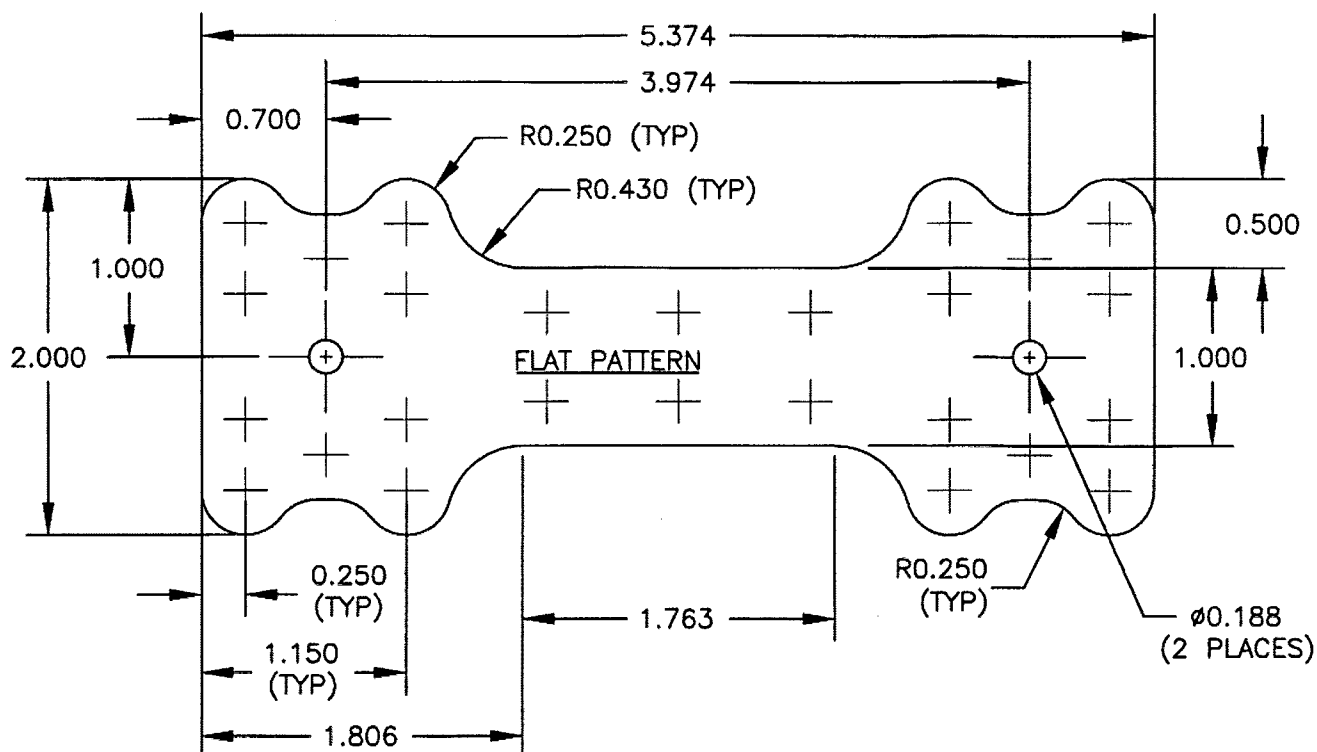
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3286	REV. A SHEET 1 OF 2
DATE 04.05.06		TITLE GROUND HANDLING PARTS	SCALE 1:1
A	04.05.06	NEW ISSUE	



BENDING DETAIL

R1.51

RELEASED
04.06.22

D3286-1 DOUBLER

- 1) MATERIAL: AISI 304/316 SS SHEET 0.125" THICK
(REF DART SPEC. M304S11GA)
- 2) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

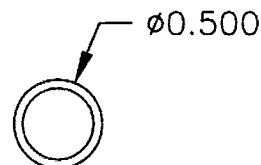
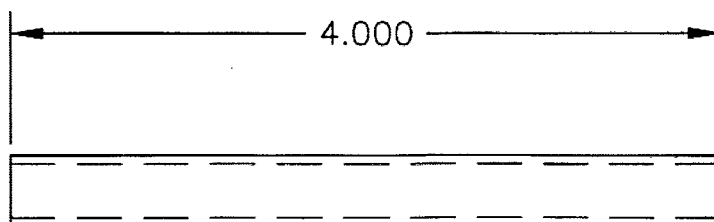
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CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3286	REV. A SHEET 2 OF 2
DATE 04.05.06		TITLE GROUND HANDLING PARTS	SCALE 1:1



D3286-3 SPACER

- 1) MATERIAL: AISI 304/316 SS TUBING, 0.500 O.D. x 0.049 WALL
(REF DART SPEC. M304TR0.500W.049)
- 2) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED
04.06.22 *CP*

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